

# Work Order ID 71740

Monday, July 11, 2011 8:26:11 AM



Page 1

Item ID:	D3838-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly (Basket Lid, RH)					
Start Date:	7/11/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	7/14/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3838	Rev A

100	0.00
	Large Fab
Large Fab	Memo
Large Fab	1- cut D3838-2 and D3838-3 rib as per dwg D3838
	2- remove identification markings
	3- deburr
	4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838
	A/R ER316 S.S. Rod Batch: <u>M114649</u>
	5- c'sink hole as per dwg
	6- grind weld flush where indicated on dwg D3838
	7- weld D3759-1 bushing as per dwg D3838
	A/R ER316 S.S. Rod Batch: <u>M114649</u>
	8- grind bushing weld flush as per dwg dwg D3838
	9- deburr hole if necessary

PMB 11/07/21 (2)  
lpl 11.07.21

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Item ID: D3838-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/11/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				<u>11</u>	<u>07</u>	<u>21</u>	<u>(2)</u>
120  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				<u>11.07.21</u>			<u>(2)</u>
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>WAS</u>  Memo	0.00  0.00				<u>11.07.21</u>			<u>(2)</u>


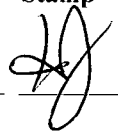
**Work Order ID 71740**

Monday, July 11, 2011 8:26:11 AM

Page 3

Item ID: D3838-042 Accept  Setup Start   
Revision ID: Stop   
Item Name: Rib Assembly (Basket Lid, RH)  
Start Date: 7/11/2011 Start Qty: 2.00  Cust Item ID:  
Required Date: 7/14/2011 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00						11/17/21	

11-07-21  
(2)

# Picklist Print

Monday, July 11, 2011 8:29:16 AM

Page 1

Work Order ID: 71740

Parent Item: D3838-042

Parent Item Name: Rib Assembly (Basket Lid, RH)


Start Date: 7/11/2011

Required Date: 7/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 		Manufactured	No			100	Each	215.0000	1	2			

Bushing

Location	Loc Qty	Loc Code
WA	200	
69202	200	
WA005	15	
66489	2	
66870	13	

2 PMB 11/07/20

M304TS0.750W.065

Purchased

No

100

f

697.9792

1.0317

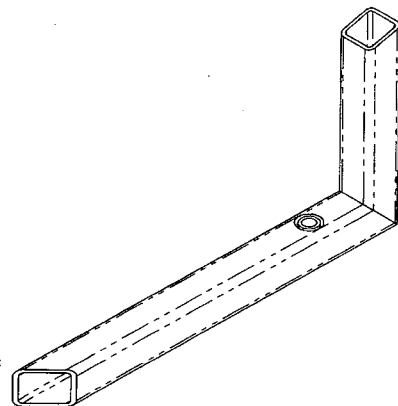
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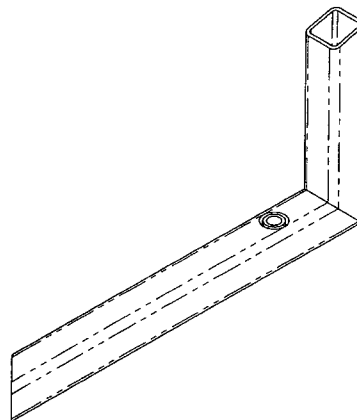
304 SQ Tube .75x.75x.065W

Location	Loc Qty	Loc Code
MAT018	91.83716	
117598	14.13846	
117636	77.6987	
WA	500	
118181	500	
WA007	106.1419906	
116267	99.549272	
116763	6.5927186	

2.172 PMB 11/07/20



**D3838-041 RIB ASSY (BASKET LID, LH)**



**D3838-042 RIB ASSY (BASKET LID, RH)**

- NOTES:**  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.54 lbs

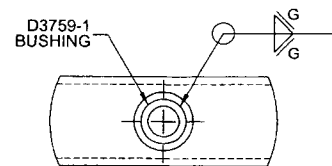
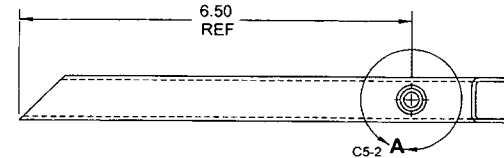
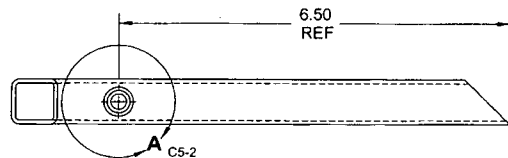
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1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 71770

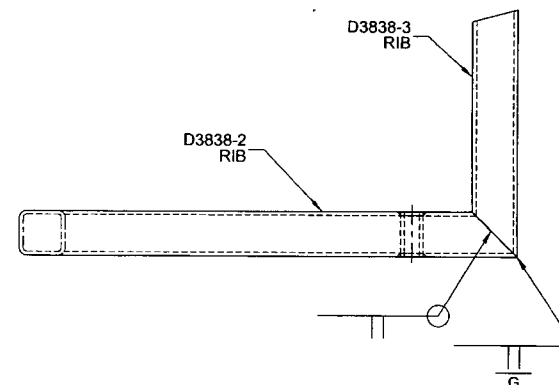
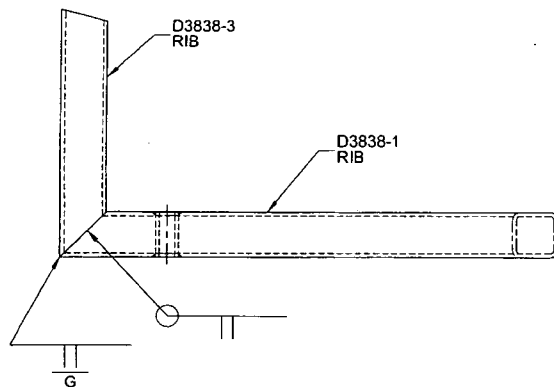
*11-07-11*

**RELEASED**  
*08/11/11*

A		NEW ISSUE		MB		08.10.08	
REV.		DESCRIPTION				BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA					
DRAWN							
CHECKED		DRAWING NO.		REV. A			
MFG. APPR.		D3838		SHEET 1 OF 3			
APPROVED		TITLE		SCALE			
DE APPR.		RIB ASSY (BASKET LID)		NTS			
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**DETAIL A**  
D2-2  
D7-2 SCALE 2X



**D3838-041 RIB ASSY (BASKET LID, LH)**

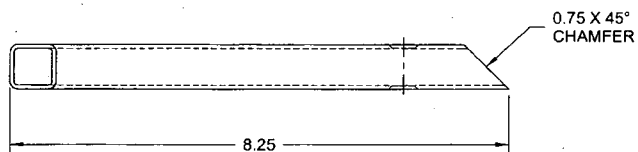
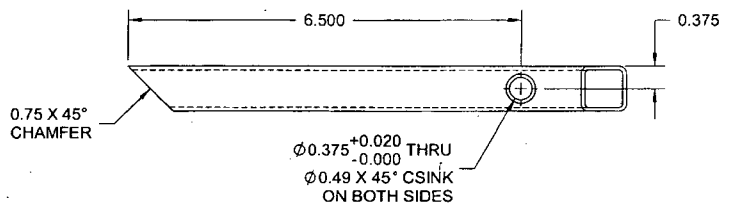
**D3838-042 RIB ASSY (BASKET LID, LH)**

**RELEASED**  
08/11/18/19

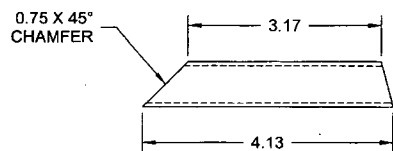
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MFG. APPR.		TITLE	SHEET 2 OF 3
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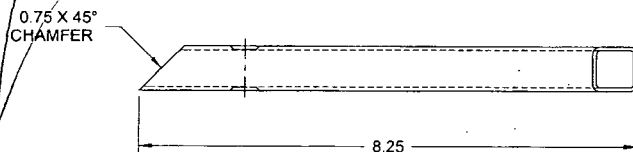
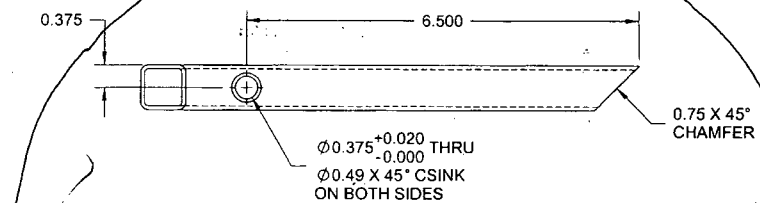
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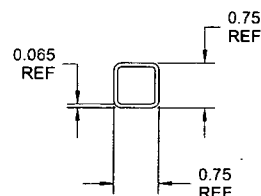
**D3838-1 RIB**



**D3838-3 RIB**



**D3838-2 RIB**



**TYPICAL SECTION VIEW**

71740

**RELEASED**  
08/10/08

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3838	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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